

What to do when crimping die get stuck

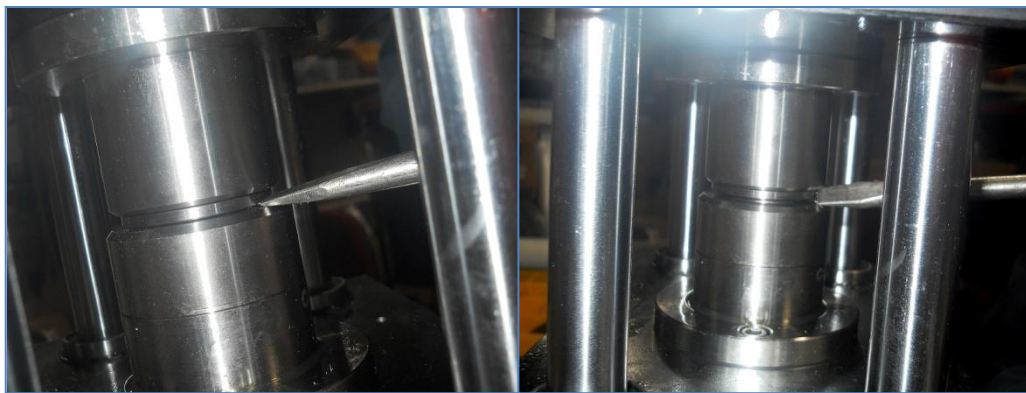
Coin cell battery cases occasionally get deformed while being crimped because of crimping die misalignment after 3-6 months use. Deformed cases may get stuck into the crimping dies and cause them to lock up. Certain procedures and methods can be performed in order to release the crimping dies from being locked up.

Step 1:

The first step that needs to be performed is releasing the hydraulic pressure by turning the hydraulic valve counter clockwise or towards the “Unlock” direction.

Step 2:

After releasing the hydraulic pressure use a flat head screw driver to pry the upper and lower crimping dies open. Simply twist the screw driver and use the leverage to separate the dies from each other. Move on to Step 3 if this method does NOT work.



Step 3:

If the screw driver method failed to work, the upper crimping die needs to be removed. This is done by loosening a hex screw on the top. The crimping die usually drops when the hex screw is removed.



However, if the upper crimping die is stuck, loosen it by lightly tapping the die with the butt of a screwdriver handle or rubber hammer.



Note:

The plate on the die can be removed using a pair of grip lock pliers if a battery case is stuck in the plate. Once removed, tap the battery case out of the die plate.



Re-alignment of Crimping Dies

Re-alignment should be performed if the crimping dies get locked up frequently as a misalignment in the dies could cause the battery case to deform and get stuck in the dies. Perform the following steps to re-align the crimping dies.

Step 1:

Immediately after releasing the dies from a lock, loosen the two hex screws holding the lower crimping die (please note the upper crimping die should be secured in place with its hex screw tightened at this point).

Step 2:

Engage the hydraulic pressure by turning the hydraulic valve towards the clockwise or “Lock” direction.

Step 3:

Slowly close the gap between the dies by raising the lower crimping die with the compression handle. Stop pumping the handle when the gap is barely enough to fit a fully assembled coin cell battery.

Step 4:

Insert an assembled coin cell battery (CR20XX Series, MTI has provided one within the shipping package) into the cell holder on the lower crimping die. Then pump the compression handle again to close the gap between both dies. At this point, both dies are aligned and the hex screws of the lower crimping die needs to be tightened. The die re-alignment is complete.